



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14101W18-PO

Job Sheet 185058



Part No: RBE105-14101W18-PO

Job Qty: 1 ea

Part Name: Pressing-In Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE105-14101W18 Rev.1 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		11/16/18	0.00	0.00	Purchasing		DEC 12 2018
110	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging2		DEC 12 2018
120	QC	1 pcs		11/16/18	0.00	0.00	QC6		38
130	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	1 Ea		11/16/18	0.00	0.00	QC21		DEC 12 2018

Part Op 100 - Issue P/O: _____ MANUFACTURE RBE105-14101W18 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-14101W18P	Pressing-In Tool	1 (1 ea)	100-Purchasing	S137035

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE105-14101W18P	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 12:49 PM dart.Lussier.Patrick



Container No: S137039



Part: RBE105 - 14101W18

Job No: 185058

Serial No/Batch: S137039

Revision: 1

Inspector:

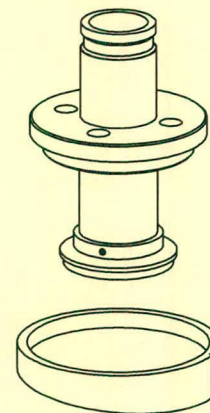
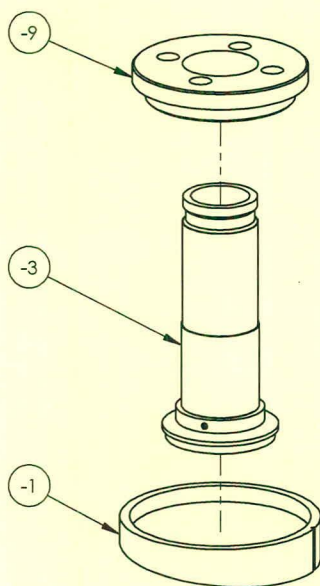
Exp Date:

Instructions:

Date: 12/12/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	8/31/2016	DPD	JAG



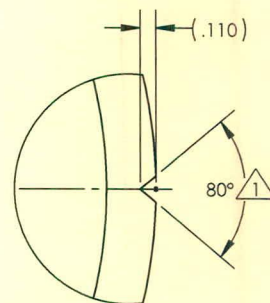
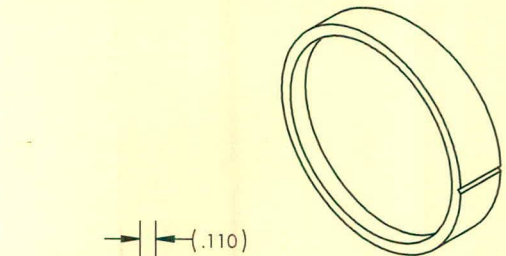
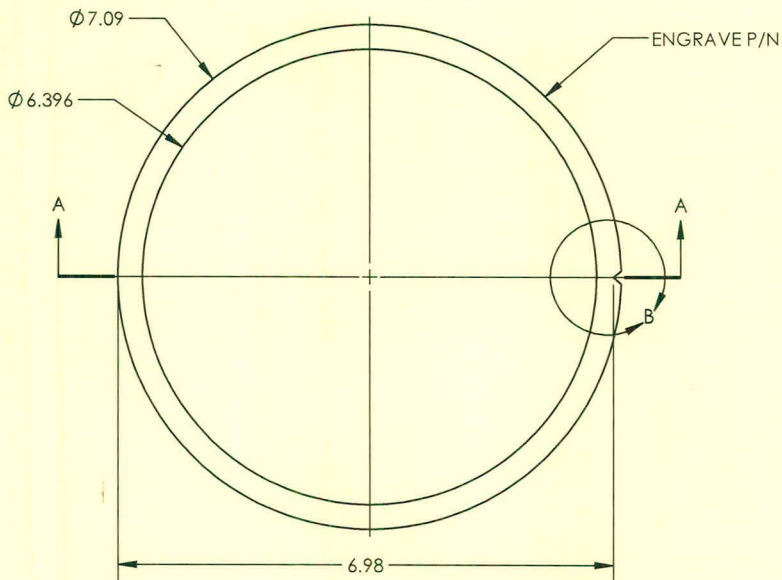
NOTE:
REF. EUROCOPTER T/N: 105-14101W18.

DART AEROSPACE	
TITLE PRESSING - IN TOOL	
DWG NO. RBE105-14101W18	REV 1
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .01R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL EC145	
SCALE 1:5	DATE 1/20/2016
SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SUPPORT	BLACK PHENOLIC	GRADE C (PORT PLASTICS)	2
	X		-3	1	DRIFT ASSEMBLY			3
	1		-5		DRIFT TUBE	6061		4
	1		-7		DRIFT BASE	4140/4142		5
			-9	1	CENTERING DISK	WHITE DELRIN/ACETAL		6
	2	B/O	-11		SPRING PIN	STEEL	M4 X 12mm (MCMaster-CARR #91611A205)	3
	ASSY -3							

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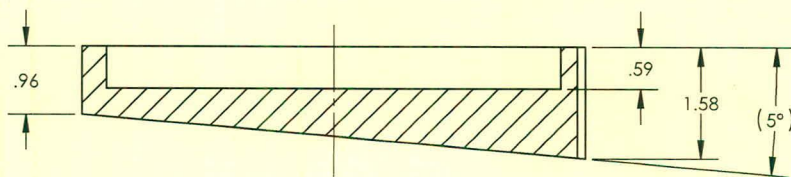
REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



DETAIL B
SCALE 1:1

NOTE:

① FILL IN NOTCH WITH WHITE PAINT.



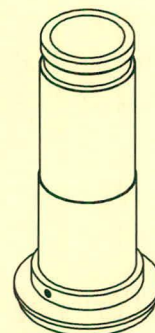
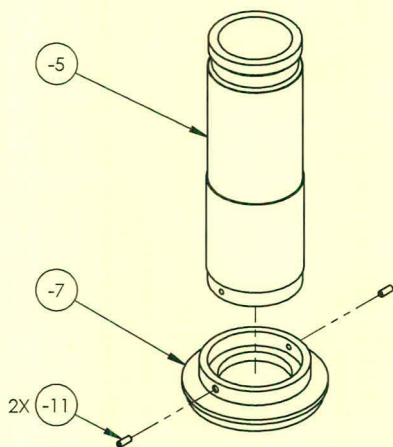
SECTION A-A

①
SUPPORT

DART AEROSPACE	
TITLE PRESSING - IN TOOL	
DWG NO. RBE105-14101W18-1	REV 1
MAT'L BLACK PHENOLIC HEAT TREAT FINISH SPEC DRAWN BY: DUERFELDT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓ 1. BREAK ALL SHARP EDGES .016 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145	
SCALE 1:2	DATE 1/20/2016
SHEET 2 OF 6	

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REVISONS			
REV	ECR	DESCRIPTION	DATE

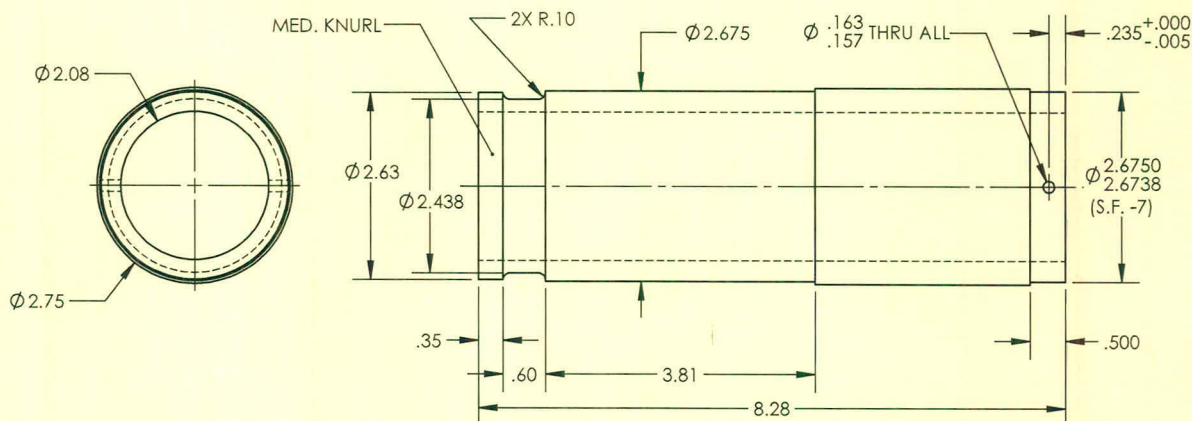
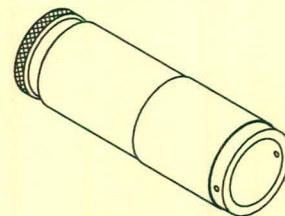


(-3)
DRIFT ASSEMBLY

DART AEROSPACE	
TITLE PRESSING - IN TOOL	
DWG NO. RBE105-14101W18-3	REV 1
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
	EC145
SCALE 1:4	DATE 1/20/2016
SHEET 3 OF 6	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



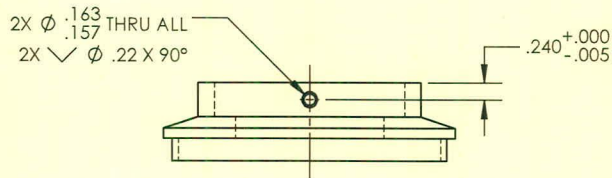
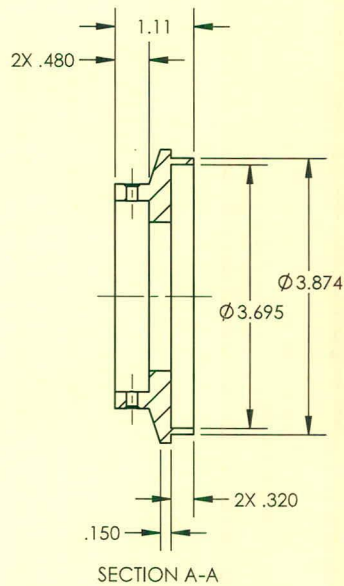
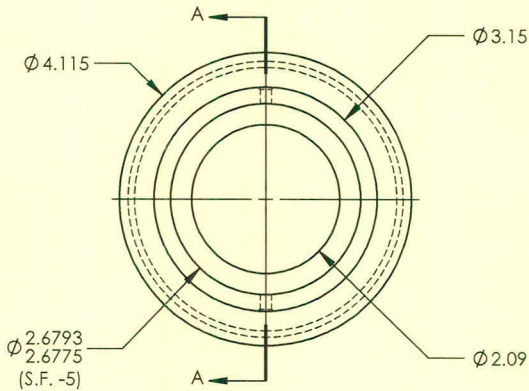
(-5)

DRIFT TUBE

DART AEROSPACE	
TITLE PRESSING - IN TOOL	
DWG NO. RBE105-14101W18-5	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
SPEC MIL-A-8625, TYPE II, CLASS I	.XX $\pm .01$ ANGLES $\pm 5^\circ$
	.X $\pm .1$ SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER
QA APPR: LINDSAY	ASME Y14.6M-2009
APPROVED: GILBERT	USED ON MODEL
	EC145
SCALE 1:2	DATE 1/20/2016
	SHEET 4 OF 6

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

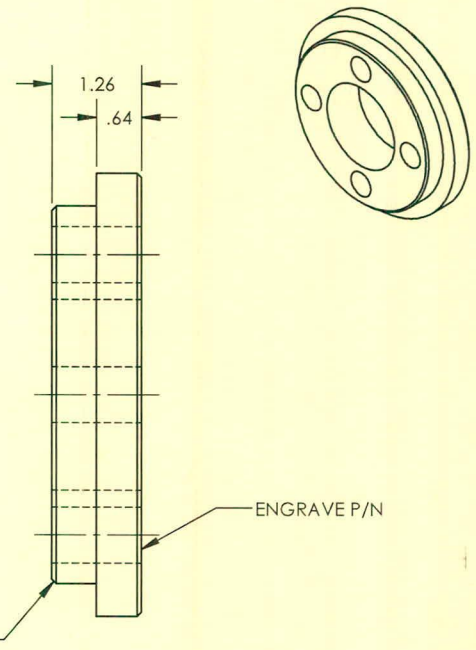
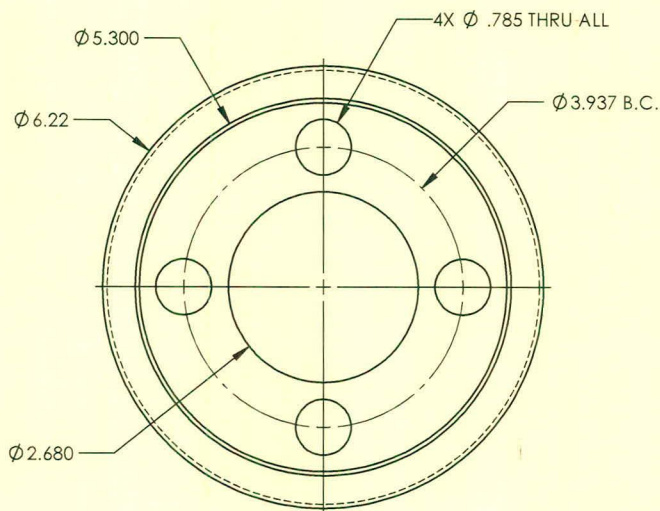


(-7)
DRIFT BASE

DART AEROSPACE	
TITLE PRESSING - IN TOOL	
DWG NO. RBE105-14101W18-7	REV 1
MAT'L 4140/4142 TREAT RC 40-46 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .005 FRACTIONS ± 1/8 .X ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES Ø1/8 x 45° OR Ø1/8 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL EC145	
SCALE 1:2	DATE 1/20/2016
SHEET 5 OF 6	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



(-9)
CENTERING DISK

DART AEROSPACE	
TITLE PRESSING - IN TOOL	
DWG NO. RBE105-14101W18-9	REV 1
MAT'L WHITE DELRIN/ACETAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125 1. BREAK ALL SHARP EDGES .016 X 45° OR .016R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT EC145	
SCALE 1:2	DATE 1/20/2016
SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041411
PO Date: 10/22/18
Due Date: 12/14/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185055	RBE105-14101W2P			Outer Needle Bearings Extractor	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,100.00/Ea	\$4,100.00
Line Item Note REV 1													
2	185058	RBE105-14101W18P			Pressing-In Tool	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$1,950.00/Ea	\$1,950.00
Line Item Note REV 1													
3	185059	RBE105-45045W1P			Trammel	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,900.00/Ea	\$4,900.00
Line Item Note REV 1													
4	185061	RBE105W27P			Main Gear Box Hoisting Device	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
5	185063	RBE105-31501W6P			Puller	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$820.00/Ea	\$820.00
Line Item Note REV 1													
6	185064	RBE105-31702W24P			Tail Rotor Fork Shaft Check	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
7	185065	RBE105-13101W3P			Disassembly / Assembly - Rotating Control Rod	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$5,050.00/Ea	\$5,050.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185106	RBE105-14101W12-1P			Mounting Shaft Assembly	Firmed	-	12/14/18 DEC 12 2018	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note Sub assy on part # RBE105-14101W12 REV 1													
9	185107	RBE105-14101W12-9P			Mounting Base	Firmed	-	12/14/18 DEC 12 2018	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note Sub assy on part # RBE105-14101W12 REV 1													
Grand Total:												\$17,860.02	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 12/11/18 9:11 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24364
Shipment Date: 10-Dec-2018
Ship Via: our truck
Order Number: 3112
Order Date: 10/24/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041411 ✓
Terms: Net 60 Days

Quantity								Job
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number
1	1	1 ✓	0	0	EA	DART-RBE105-14101W2P Extractor for Outer Needle Bearing	1	3112-01
2	1	1 ✓	0	0	EA	DART-RBE105-14101W18P Pressing - In Tool	1	3112-02
3	1	1 ✓	0	0	EA	DART-RBE105-45045W1P Trammel	1	3112-03
5	1	1 ✓	0	0	EA	DART-RBE105-31501W6P Puller	1	3112-05
7	1	1 ✓	0	0	EA	DART-RBE105-13101W3P Pitch Link Tool	1	3112-07
8	1	1 ✓	0	0	EA	DART-RBE105-14101W12-1P MOUNTING SHAFT ASSEMBLY	1	3112-08
9	1	1 ✓	0	0	EA	DART-RBE105-14101W12-9P MOUNTING BASE	1	3112-09

DAS
38
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number
1 /	RBE105-14101W2P ✓	Outer Needle Bearings Extractor	1	PO041411 /
1 /	RBE105-14101W18P ✓	Pressing-In Tool	1	PO041411 /
1 /	RBE105-45045W1P ✓	Trammel	1	PO041411 /
1 /	RBE105-31501W6P ✓	Puller	1	PO041411 /
1 /	RBE105-13101W3P ✓	Pitch Link Tool	-	PO041411 /
1 /	RBE105-14101W12-1P ✓	Mounting Shaft	1	PO041411 /
1 /	RBE105-14101W12-9P ✓	Mounting Base	1	PO041411 /

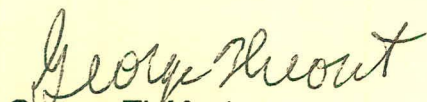
DAS
38
9-89

No deviations for these part

Material supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Théoret

Vankleek Hill, December 10, 2018

